

Date: Thursday, 8/23/2007 11:52:16 AM  
 User: Kim Johnston

## Process Sheet

36

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	PEDAL ASSEMBLY		
Job Number	34230			Part Number	D412704041		
Estimate Number	11005			Drawing Number	D412-704-041 REV A		
P.O. Number	N/A			Project Number	N/A		
This Issue	8/23/2007 S.O. No. N/A			Drawing Revision	A		
Prsh Rev.	NC			Material	N/A		
First Issue	N/A			Due Date	8/3/2007		
Previous Run	X32814			Qty:			
Written By				Um:	Each		
Checked & Approved By	<u>JLJ 07/08/23</u>						
Comment	Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF Est Rev:C 06.03.08 Re-format EC Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM Est Rev:E 07.05.02 Reformat EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:			Description :
1.0	D3204041			Pedal Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	Pick:	Qty 1	Part number D3204-041	Description Pedal Assembly batch 32822
				AS 07/12/10 X2
2.0	D32051			Bracket
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	Pick:	Qty 1	Part number D3205-1	Description Bracket batch B 30830
				AS 07/12/10 X2
3.0	D32053			Back Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	Pick:	Qty 1	Part number D3205-3	Description GHW Bracket batch 35269
				AS 07/12/10 X2
4.0	D32061			Pedal Arm
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	Pick:	Qty 1	Part number B34239(X1) B29915(X1)	Description batch AS 07/12/10 X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3206-1 Pedal arm

5.0 D3209041

Bracket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-041	Bracket	<u>B30832</u>

6.0 AN310A

Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	<u>M17566</u>

7.0 AN3154R

Nut

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	<u>M17566</u>

8.0 AN410A

Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	<u>M104603</u>

9.0 AN412A

Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	<u>108143</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN413A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	106043

AS 07/12/10 (R)

11.0 AN960JD10 Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	M105792

AS 07/12/10 (R)

12.0 AN960JD416 Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M105906

AS 07/12/10 (R)

13.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M105728

AS 07/12/10 (R)

14.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS21042L3	Nut	M105558

AS 07/12/10 (R)

15.0 MS21042L4 Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	M105054

AS 07/12/10 (R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0 MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

AS of 7/12/10

(2)

17.0 MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

AS of 7/12/10

(2)

18.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Pro

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

ml07/12/10 X2

X2

19.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS of 7/12/12 (X2)

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



KV

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

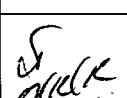
Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M104374

LC 7/12/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/12/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	# 18.0	one D3204-041 has a bend in the location of the button where D3204-7 bushing was pressfit. (w/o# 32822)	J 07/12/13	Remove all hardware and re-label with correct part and photo mark re-stock	N/A	✓	✓	 07/12/13
			J	Scrap and destroy the non-conforming part (D3204-041)	N/A	✓	✓	 07/12/13
			J 07/12/13	Straighten D3204-041 to allow clearance when mating	SP 07/12/13	✓ 07/12/13	J 07/12/13	 07/12/13

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Drawing Name: PEDAL ASSEMBLY

Job Number: 34230

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0 AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description  
2 AN3-6A Bolt

batch  
*M100187*

23.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: *M105558*

*C 7/12/12 (2)*

24.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*C 7/12/12 (2)*

25.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*C 7/12/12 (3)*

26.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 7/12/13*

Job Completion



*in 2007/12/13*

*U*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPilot's EMERGENCY CARGO RELEASE KIT (BELL 212/ 214/ 412)
	X				D205-704-013	COPilot's EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
					D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
					D3205-1	PEDAL BRACKET (OR ECM 999703-1)
					D3205-3	BACK PLATE (OR ECM 999709-5)
					D3206-1	PEDAL ARM (OR ECM 999704-1)
					D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
				1	D3258-1	ANGLE BRACKET
					1	AN315-4R
			5	2	AN960JD10	NUT
			4	2	AN960JD10L	WASHER
			11		AN960JD416	WASHER
			3		AN960JD416L	WASHER
				3	3	NAS509-3
			3	2	MS21042L3	NUT (OR MS21042-3)
				5	MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
			1		MS24694-S102	SCREW
	2				MS35489-10	GROMMET
				1	1	AN3-5A
			2		AN3-6A	BOLT
			1		AN3-10A	BOLT
				1	1	AN3-13A
			1		MS9519-10	BOLT
			1		AN4-10A	BOLT
			2		AN4-12A	BOLT
			1		AN4-13A	BOLT

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